



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4776-3

Job Sheet 179927



Part No: D4776-3

Job Qty: 4 ea

Part Name: Skidtube Clevis



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/26/18

Job Tracking No:

Due Date: 6/28/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV D SHEET 2 IPP REV A: NEW ISSUE JFS 13/03/07 VERIFY BY: JLM IPP REV:B 13.09.26 AS PER REV.B DD VERF:JLM IPP REV:C AS PER REV. PC1 JFS 13/11/07 VERIFY BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	6/28/18	6/28/18	0.00	0.00	Start Up Machining-3		mark 15/6/27
100	Bandsaw	4 pcs	6/28/18	6/28/18	0.00	0.07	Bandsaw1		11
110	CNC Vertical Machining	4 pcs	6/28/18	6/28/18	0.26	3.48	HAAS1-5		11
120	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC2 Machining-3		11
130	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC8 Machining-3		11
140	HandFinish	4 pcs	6/28/18	6/28/18	0.00	0.11	HandFinish1		11
150	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC7-4		11
160	Powdercoat	4 pcs	6/28/18	6/28/18	0.00	0.05	Powdercoat1		11
170	QC	4 pcs	6/28/18	6/28/18	0.00	0.00	QC3		11
180	Packaging	4 pcs	6/28/18	6/28/18	0.00	0.00	Packaging3-2		11
190	QC21-SA	4 Ea	6/28/18	6/28/18	0.00	0.00	QC21		11

Part Op 100 - Cut Blank at 4.400"

Descriptions: 110 - 1-Machine per folio FB168

160 - START TIME:

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.500X2.500	6061-T6 Bar 1.50 X 2.50	1.4680 ft (.367 ea)	90-Start up Operation	

Job Allocations



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Required
1

Inventory
54

Allocated
0

Container No: S084688



Part: D4776-3

Job No: 179927

Serial No/Batch: S084688

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/27/18

Plex 6/26/18 10:31 AM dart.lacelle.linda

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Skidtube Clevis	4.250Inches ± 0.030	4.280 4.220		4.250
2	Skidtube Clevis	2.250Inches ± 0.030	2.280 2.220		2.255
3	Skidtube Clevis	1.688Inches ± 0.010	1.698 1.678		1.689
4	Skidtube Clevis	0.880Inches ± 0.030	0.910 0.850		.876
5	Skidtube Clevis	0.510Inches $+ 0.010$ $- 0.000$	0.520 0.510		.512
6	Skidtube Clevis	1.063Inches ± 0.010	1.073 1.053		1.063
7	Skidtube Clevis	1.380Inches ± 0.030	1.410 1.350		1.380
8	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160		.187
9	Skidtube Clevis	1.000Inches ± 0.030	1.030 0.970		1.001
10	Skidtube Clevis	0.484Inches $+ 0.006$ $- 0.001$	0.490 0.483	Diameter	.486
11	Skidtube Clevis	0.500Inches ± 0.030	0.530 0.470		.497
12	Skidtube Clevis	0.550Inches ± 0.030	0.580 0.520		.547
13	Skidtube Clevis	3.150Inches ± 0.010	3.160 3.140		3.151
14	Skidtube Clevis	1.130Inches ± 0.030	1.160 1.100		1.127
15	Skidtube Clevis	0.688Inches ± 0.010	0.698 0.678		.691
16	Skidtube Clevis	0.397Inches $+ 0.006$ $- 0.001$	0.403 0.396	Diameter	.399
17	Skidtube Clevis	1.813Inches ± 0.010	1.823 1.803		1.815
18	Skidtube Clevis	0.190Inches ± 0.030	0.220 0.160	Radius	.190
19	Skidtube Clevis	0.130Inches ± 0.030	0.160 0.100	Radius	.130
20	Skidtube Clevis	0.440Inches ± 0.030	0.470 0.410	Radius	.440
21	Skidtube Clevis	0.125Inches ± 0.010	0.135 0.115		.127
22	Skidtube Clevis	0.380Inches ± 0.030	0.410 0.350		.380
23	Skidtube Clevis	0.750Inches ± 0.030	0.780 0.720		.750
24	Skidtube Clevis	0.250Inches ± 0.030	0.280 0.220	Radius	.250